

Date: Thursday, 12/20/2007 3:17:15 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36466A02	
Estimate Number : 10144	
P.O. Number : N/A	Part Number : D20136
This Issue : 12/20/2007 S.O. No. : N/A	Drawing Number : D2013 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 29089	Material : N/A
Written By : <u>JD 07 12 21</u>	Due Date : 1/15/2008 Qty: 5 Um: Each
Checked & Approved By : <u>JD 07 12 21</u>	
Comment : Est Rev: A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.8165 f(s)/Unit Total : 9.0825 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless Tubing
 (M304TR0.750W.049)
 Batch: B 106045

FF 10-01-08

(5)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per template D2013-T5 and Dwg D2013

2-Flatten ends of D2013-6 tube as per Dwg D2013 using DT8545

3-Bend tube as per Dwg D2013 using Jig DT8201 identify as D2013-6.

4-Deburr as required

} FF 10-01-08

(5)

FF 11-01-08

(5)

FF 10-01-08

(5)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

J 08/01/14 (K5)

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/14

(5)

Job Completion



u 08.01.14

PKY

ID + stick

c 08/01/14 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

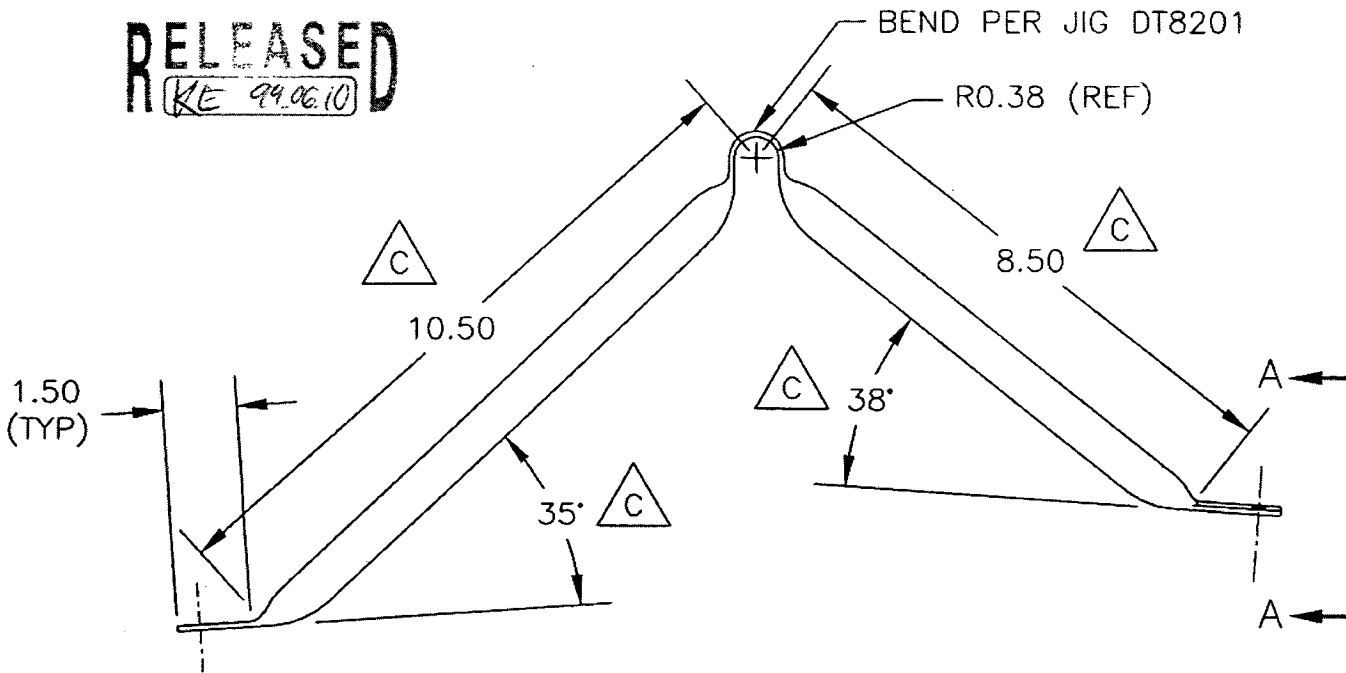
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: AD Date: 00/01/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

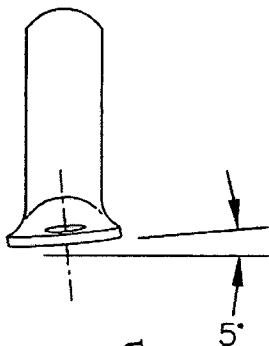
RELEASED
(KE 99.06.10)

DART



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)

DRILL $\varnothing 0.257$ (TYP)
0.400 (TYP)



VIEW A-A

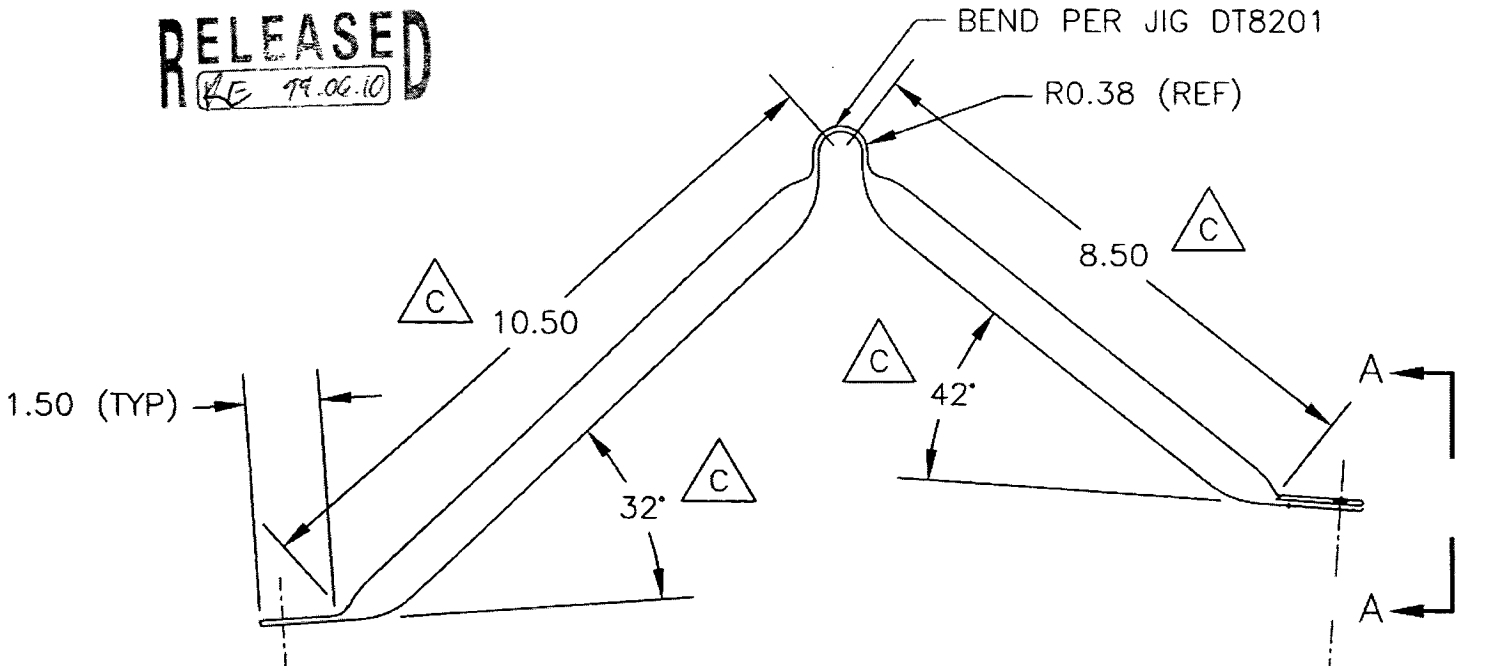
CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

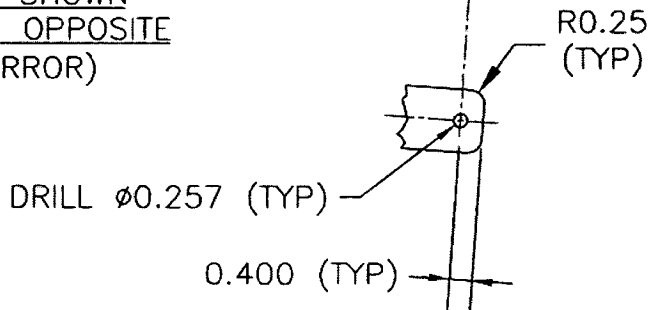
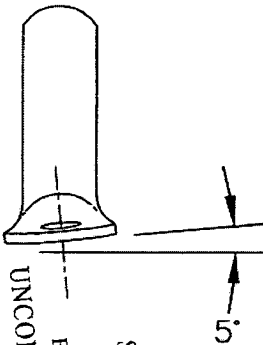
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB.	RF	
CHECKED KE	APPROVED JD	DRAWING NO. D2013
DATE 99.06.07	TITLE MIRROR BRACKET	REV. C SHEET 1 OF 3
A	90.10.22	NEW ISSUE
B	94.06.15	REDRAWN
C	99.06.07	REDRAWN, CHANGE OF DIMENSIONS
	SCALE NTS	

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RELEASED
 RE 79.06.10



D2013-3 LH SHOWN
 D2013-4 RH OPPOSITE
 (FOR 212 MIRROR)



CUT LENGTH: 23.25 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
 0.750 O.D. x 0.049 WALL

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
JB	RF		
CHECKED	APPROVED	DRAWING NO.	SHEET 2 OF 3
KE	[Signature]	D2013	
DATE	TITLE	SCALE	
99.06.07	MIRROR BRACKET	NTS	

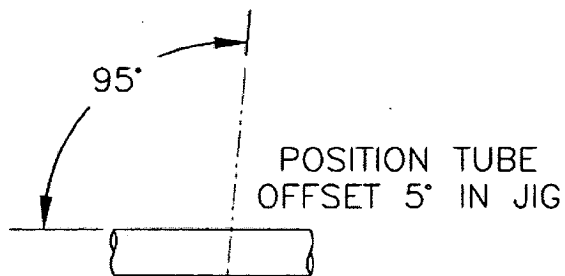
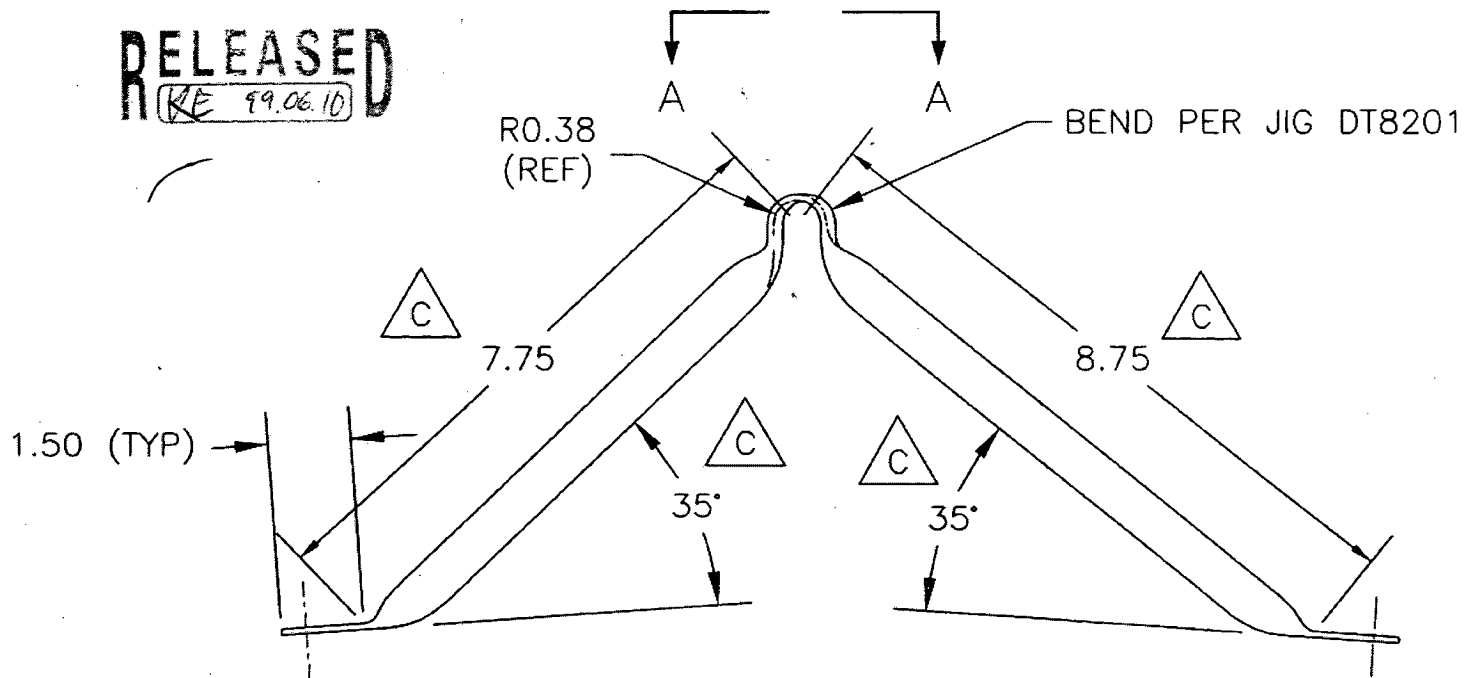
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(KE 99.06.10)

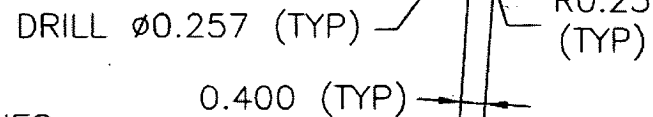
DART



DESIGN	JB	DRAWN BY	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KE	APPROVED	KE	
DATE	99.06.07	TITLE	MIRROR BRACKET	
		DRAWING NO.	D2013	
		REV. C	SHEET 3 OF 3	
		SCALE	NTS	



D2013-5 LH SHOWN
D2013-6 RH OPPOSITE
(FOR 204 MIRROR)



CUT LENGTH: 20.75 INCHES

MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 O.D. x 0.049 WALL

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